

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-008353**Date Inspected:** 23-Jul-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	Zhu Zheng Hai & Shen Fu You			CWI Present:	Yes	No	
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A	Approved WPS:	Yes	No	N/A
				Delayed / Cancelled:	Yes	No	N/A
Bridge No:	34-0006			Component:	OBG Bays 13 & 14		

Summary of Items Observed:

On this date Caltrans OSM Quality Assurance (QA) Inspector, Rory O'Kane was present during the time noted above for observations relative to the work being performed.

OBG - BAY No. 13

Shielded Metal Arc Welding Process:

Welding of weld joint SEG047-SSD9A-PP71-126 located on OBG Segment 8CW. Welder is identified as 044837. ZPMC QC is identified as Zhu Zheng Hai. The welding variables recorded by QC appeared to comply with the WPS-B-P-2214-TC-U4b-FCM-1.

Flux Cored Arc Welding Process:

Welding of weld joint SEG043-SSD12-PP74-254 located on OBG Segment 8AW. Welder is identified as 044774. ZPMC QC is identified as Zhu Zheng Hai. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-TC-U5-F.

Welding of weld joint SEG043A-SSD12-PP64-256 located on OBG Segment 8AW. Welder is identified as 0447741. ZPMC QC is identified as Zhu Zheng Hai. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-TC-U5-F.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

OBG - BAY No. 14

Shielded Metal Arc Welding Process:

Welding of weld joint SEG054A-007 located on OBG Segment 9CE. Welder is identified as 200113. ZPMC QC is identified as Shen Fu You. The welding variables recorded by QC appeared to comply with the WPS-B-P-2214-B-U2-FCM-1.

This QA Inspector noted installation of the following Structural Framing Components:

OBG Segment 9BE (Panel Point 75) FB024-006

OBG Segment 9CE (Panel Point 76) FB012-026, FB014-034, SSD18/18A-PP076

OBG Segment 9CE (Panel Point 77) FB010-029, FB013-029, SSD20/20A-PP077, FB016-034

OBG Segment 9CE (Panel Point 78) FB016-031

This QA inspector performed Ultrasonic Testing (UT) of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated a UT report for this date. The member is identified as Bottom Panel. The weld designations reviewed are as follows:

SEG056A-022, 023

SEG052A-022, 023

SEG064A-022, 023

SEG060A-012, 014

SEG064A-007, 008

SEG060A-020, 021

SEG038A-004, 007

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, who represents the Office of Structural Materials for your project.

Inspected By:	O'Kane,Rory	Quality Assurance Inspector
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Reviewed By:	Carreon,Albert	QA Reviewer
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